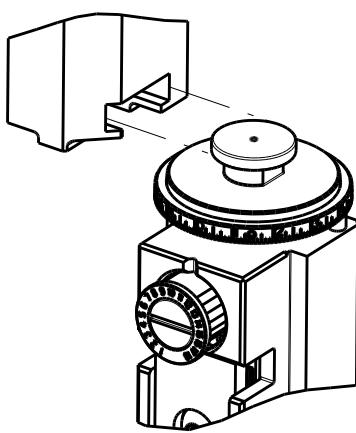
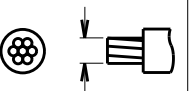


8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150611-2	A	FINE CRIMP HEIGHT ADJUST
	2150611-5	A	FINE CRIMP HEIGHT ADJUST
	2150611-6	A	NON-CRIMP HEIGHT ADJUST
	2150611-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150611-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.50 mm [.177]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: YAZAKI TERMINAL		YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: TERMIANL			
WIRE STRIP LENGTH 4.50-5.50 mm [.177-.217 IN]		 INSULATION DIAMETER RANGE Ø2.20-3.40 mm [.087-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	7113-1020 Rev WA2235	-	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
286777-1	7113-1020		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
AV 2mm ² or GXL 14 AWG		1.80+/-0.05 [.071+/- .002]		3.5
AV 1.25mm ² or GXL 16 AWG		1.60+/-0.05 [.063+/- .002]		5.7
AV 0.85mm ² or GXL 18 AWG		1.40+/-0.05 [.055+/- .002]		7.8
AV 0.5mm ² or GXL 20 AWG		1.30+/-0.05 [.051+/- .002]		9.0



- ¹ RECOMMENDED SPARE PARTS
- ² GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- ⁴ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150611-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150611-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150611-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- ⁶ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 180.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- ⁸ MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- ⁹ CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- ¹⁰ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ¹¹ WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

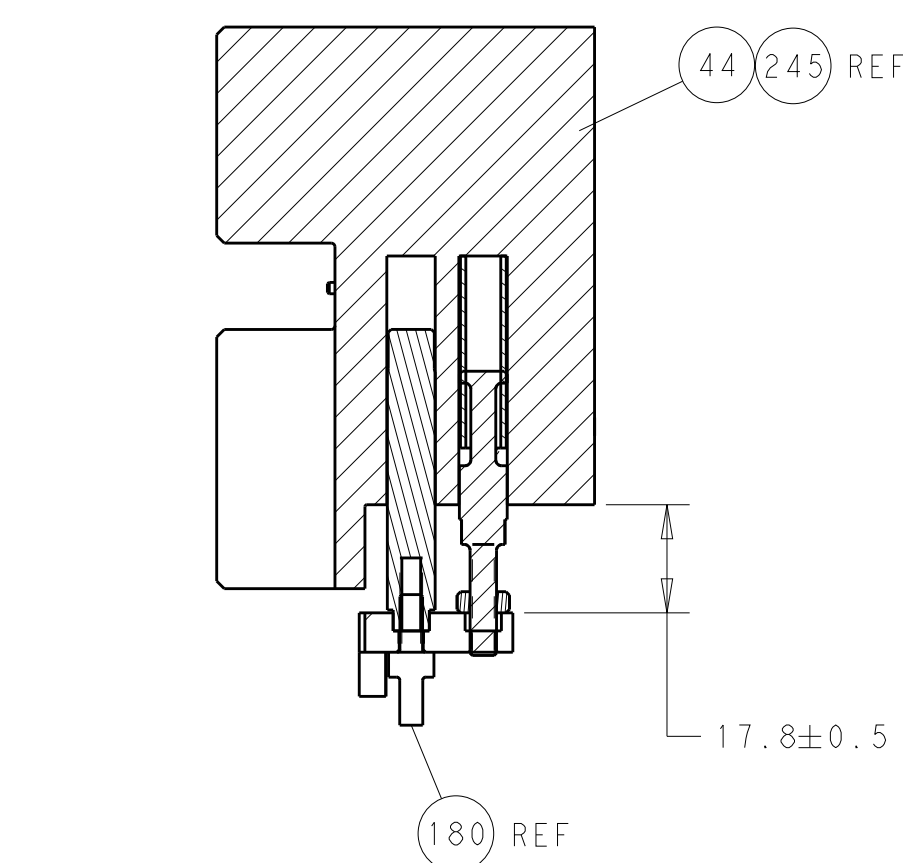
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	261
-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	2119641-1	FEED CAM, AIR FEED	248
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

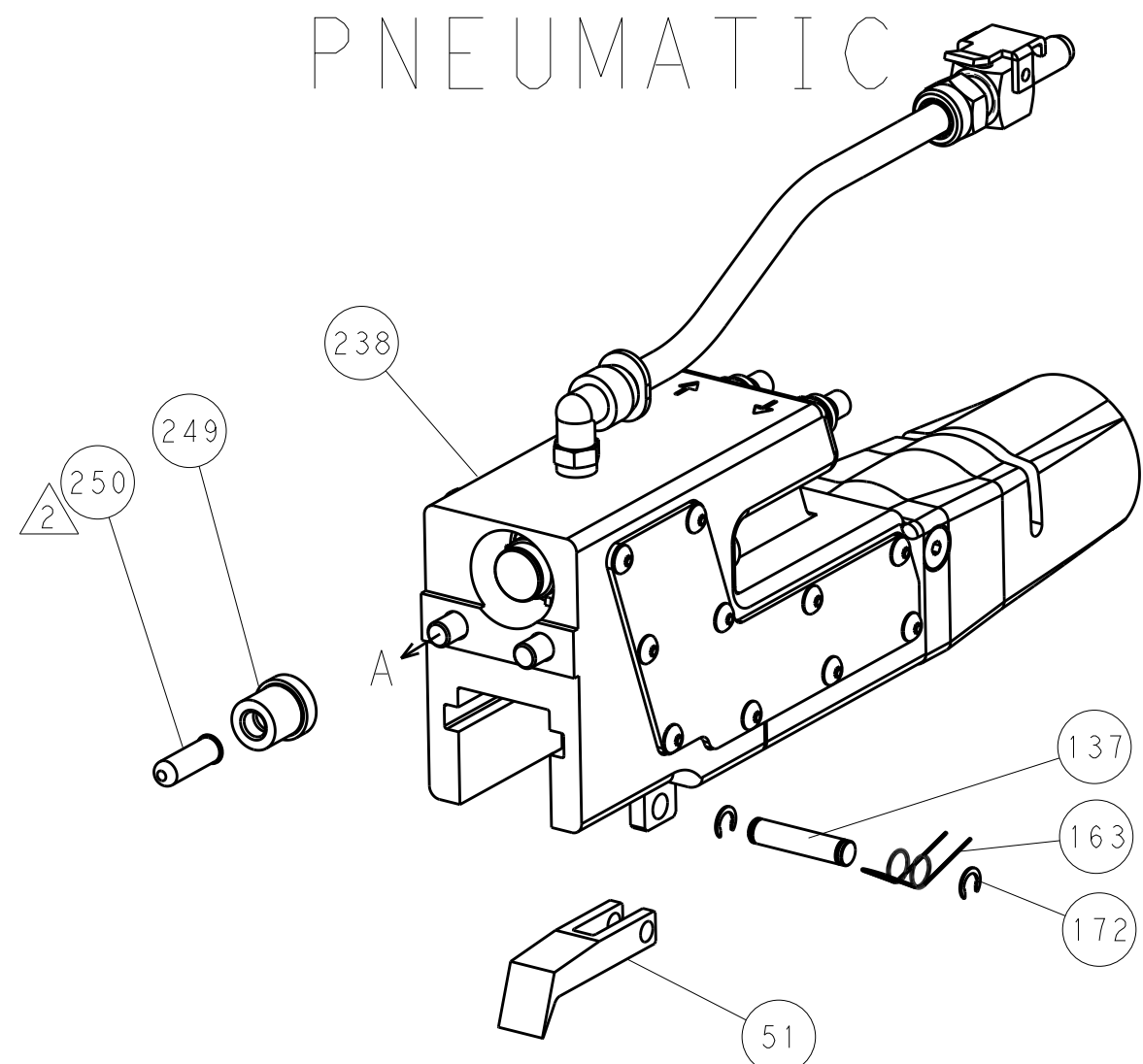
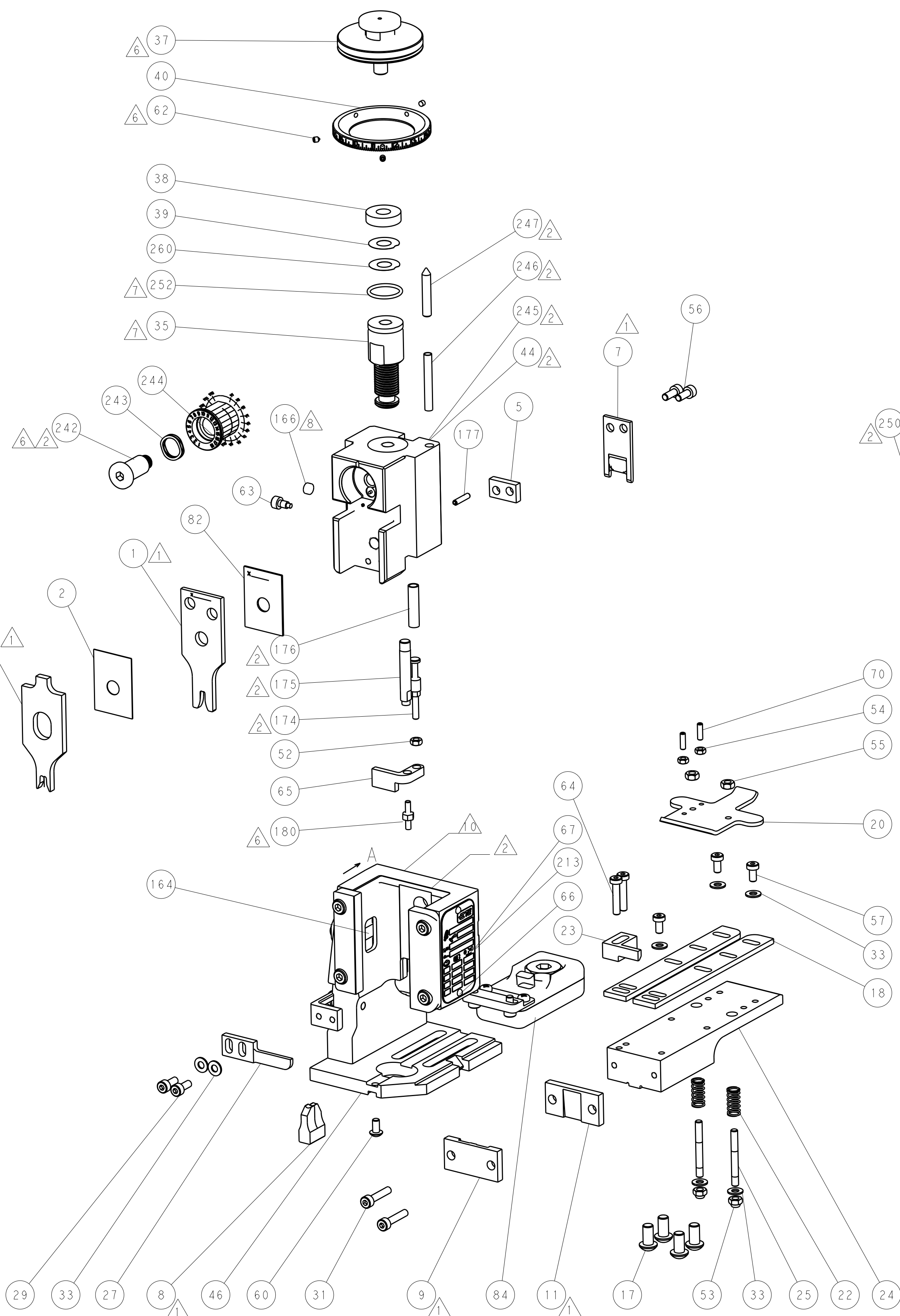
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				1	DEVELOPMENT	17AUG2015
				A	RELEASED	24SEP2015
						YY
						UG

-	1	-	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REF	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1	2-1976055-3	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	1	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140
-	-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	REF	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	455888-8	SPACER, CRIMPER	82
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73
-	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
-	1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	-	1	2119792-2	PAWL, EF, AIR	51
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	-	1	1	2119369-1	RAM, AMP STYLE, END FEED	44
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-2	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1752373-4	DRAG	20
-	2	2	2	2	1901259-6	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	690482-3	PLATE, FRONT SHEAR	9
-	1	1	1	1	1803257-4	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1-2217206-4	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	240641-4	SPACER	5
-	1	1	1	1	238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	4-1633962-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	1	1	2-456409-6	CRIMPER, WIRE .120 "F" PREMIUM	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. NO OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN T. YIN	17AUG2015	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY	17AUG2015	NAME Ocean End Feed Applicator	
		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01		PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		FINISH -		WEIGHT -	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 1 OF 4	
				REV A	

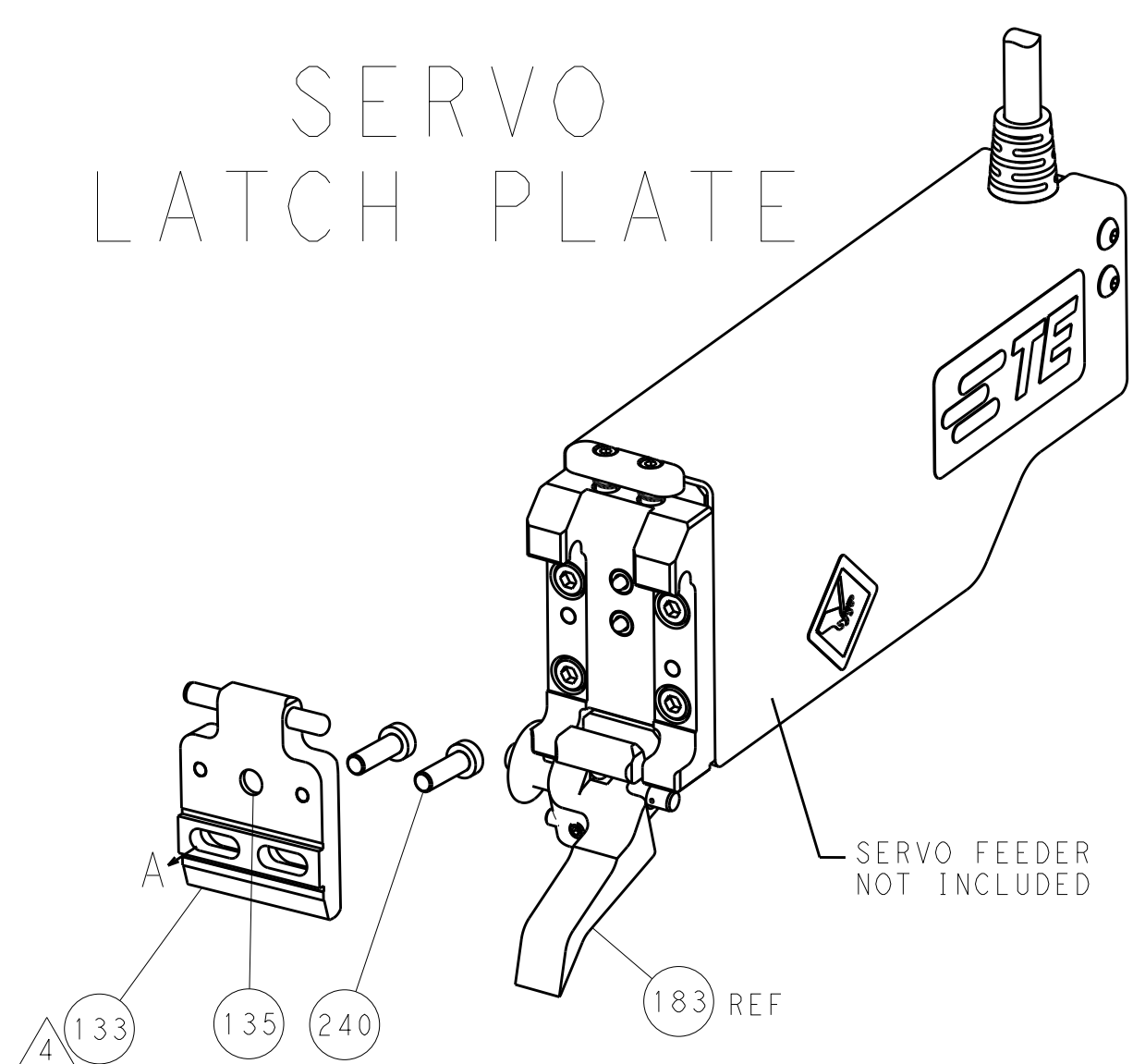
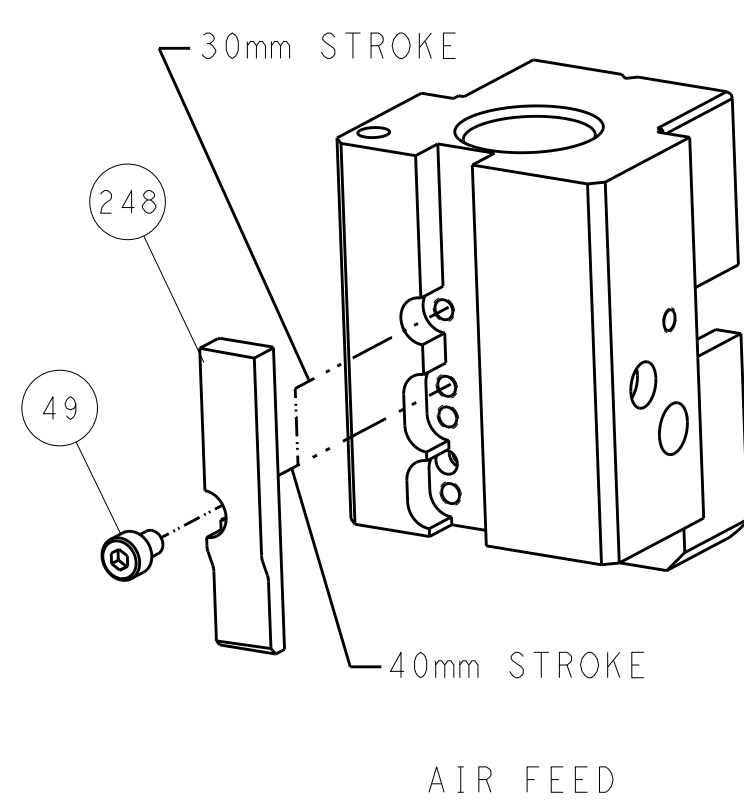


HOLDDOWN SET-UP



FEED TYPE

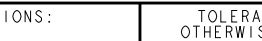
PNEUMATIC

SERVO
LATCH PLATE

CAM POSITION

AIR FEED

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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										CHK G.BAILEY		17AUG2015				Harrisburg, PA 17105-3608			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:														NAME	
mm																		Ocean End Feed Applicator	
				D PLC ±				±				PRODUCT SPEC							
				L PLC ±				±				APPLICATION SPEC							
				R PLC ±				±											
				A ° ±				±											
				B ° ±				±											
MATERIAL				FINISH				WEIGHT				SIZE CAGE CODE DRAWING NO				RESTRICTED TO			
-				-				-				A 00779 C=2150611				-			
Customer Accessible Production Drawing										SCALE 1:1		SHEET 2 OF 4		REV A					



- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150611-
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150611-
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180.
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 10 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 11 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.

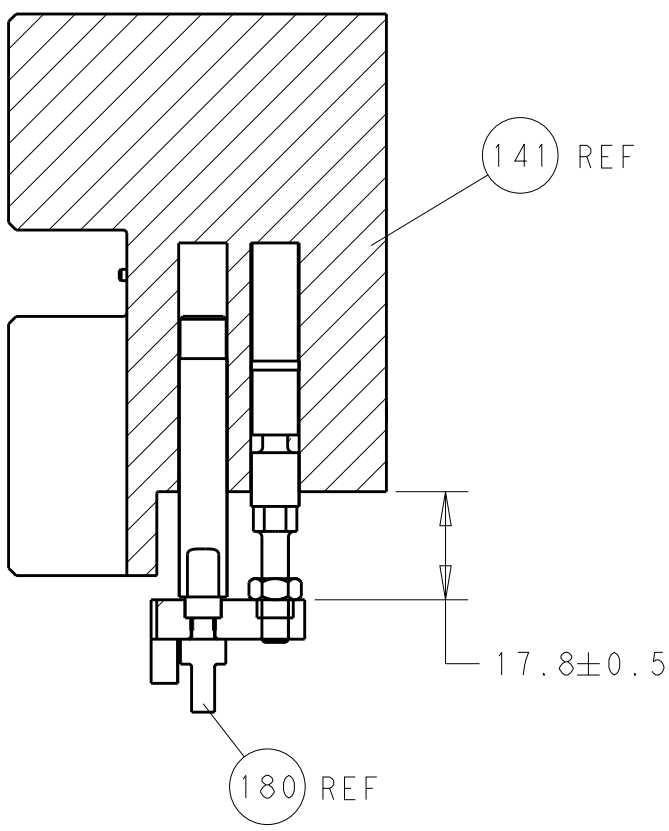
-	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	261
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-77-27-25-22	PART NO				DESCRIPTION	ITEM NO

PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE 2119599-2				LOC A	DIST 66	REVISIONS				
						P	LTR	DESCRIPTION	DATE	OWN
					-	SEE SHEET 1	-	-	-	
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI				249	
-	1	1	1	1-22279-3	SPRING, COMPRESSION				246	
-	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT				244	
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST				243	
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL				242	
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10				240	
-	-	-	1	2063440-2	AIR FEED MODULE				238	
-	-	1	-	2119740-2	TAG,IDENTIFICATION				213	
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)				186	
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY,EF				183	
-	1	1	1	2-1976055-3	STANDOFF, HOLD-DOWN				180	
-	1	1	1	6-9931111-6	PIN, SLOTTED SPRING 3.0 X 14.0				177	
-	1	1	1	8-22280-7	SPRING, COMPRESSION				176	
-	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN				175	
-	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN				174	
-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT				172	
-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY				166	
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC				164	
-	-	-	1	240638-1	SPRING, FEED FINGER				163	
-	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.				153	
-	-	-	1	2119641-2	FEED CAM, AIR FEED				152	
-	1	1	1	2119798-2	DETENT PIN				145	
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)				144	
-	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF				141	
-	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED				140	
-	1	1	1	2119092-2	BOLT, ADJUSTMENT				139	
-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854				137	
-	-	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED				135	
-	-	1	-	1633743-1	SERVO FEED LATCH ASM				133	
-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED				84	
-	1	1	1	455888-8	SPACER, CRIMPER				82	
-	1	1	1	2119791-5	DEPRESSOR, WIRE				73	
-	1	1	1	2119956-2	DOCUMENTATION PACKAGE				71	
-	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0				70	
-	1	-	1	2119740-1	TAG,IDENTIFICATION				67	
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188				66	
-	1	1	1	1901681-5	HOLDDOWN, TERMINAL				65	
-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20				64	
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT				63	
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0				62	
-	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8				57	
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10				56	
-	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4				55	
-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3				54	
-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)				53	
-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5				52	
-	-	-	1	2119792-2	PAWL, EF, AIR				51	
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0				49	
-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)				41	
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT				40	
-	1	1	1	2119957-1	APPLICATOR SHIM PACK				39	
-	1	1	1	1-2119644-2	RAM WASHER, PRECISION				38	
-	7	7	7	1-18028-2	WASHER, FLAT, REG M4				33	
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20				31	
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10				29	
-	1	1	1	240639-1	STRIPPER (MACHINING)				27	
-	2	2	2	1320906-1	STUD, THREADED				25	
-	1	1	1	1752371-5	PLATE, STRIP GUIDE				24	
-	1	1	1	240825-2	PLATE, STRIP HOLD DOWN				23	
-	2	2	2	2-22281-3	SPRING, COMPRESSION				22	
-	1	1	1	1752373-4	DRAG				20	
-	2	2	2	1901259-6	GUIDE, LOWER STRIP				18	
-	1	1	1	240644-1	PLATE, REAR SHEAR				11	
-	-	-	-	-	-				10	
-	1	1	1	690482-3	PLATE, FRONT SHEAR				9	
1	1	1	1	1803257-4	ANVIL, COMBINATION, END FEED				8	
-	1	1	1	1-2217206-4	BLADE, SLUG				7	
-	-	-	-	-	-				6	
-	1	1	1	240641-4	SPACER				5	
-	1	1	1	238011-1	BLOCK, CRIMPER SPACER				4	
1	1	1	1	4-1633962-4	CRIMPER, INSULATION F PREMIUM				3	
-	1	1	1	455888-3	SPACER, CRIMPER				2	
1	1	1	1	2-456409-6	CRIMPER, WIRE .120 "F" PREMIUM				1	
-77-27-25-22	PART NO				DESCRIPTION				ITEM NO	

[illegible]

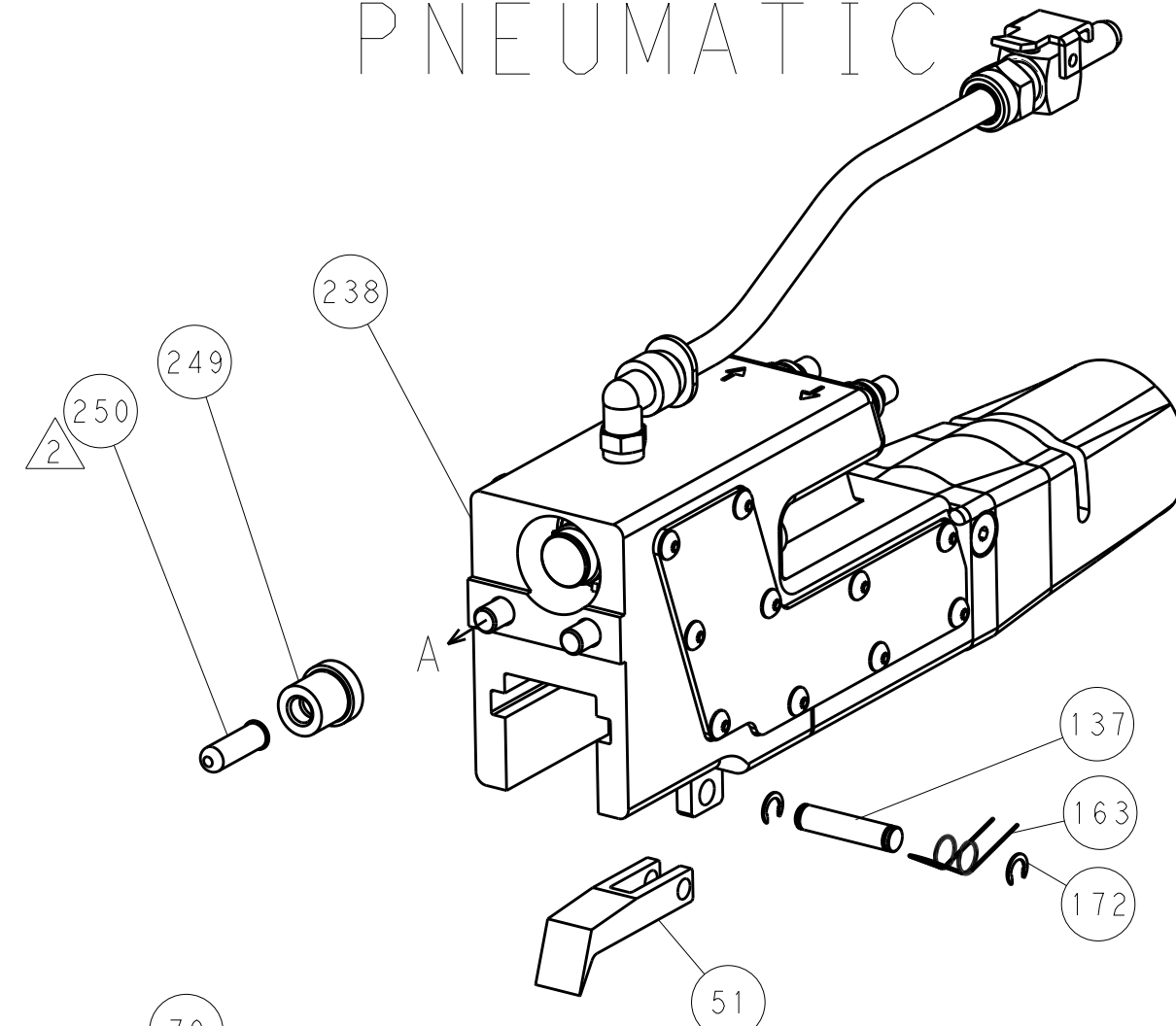
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A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
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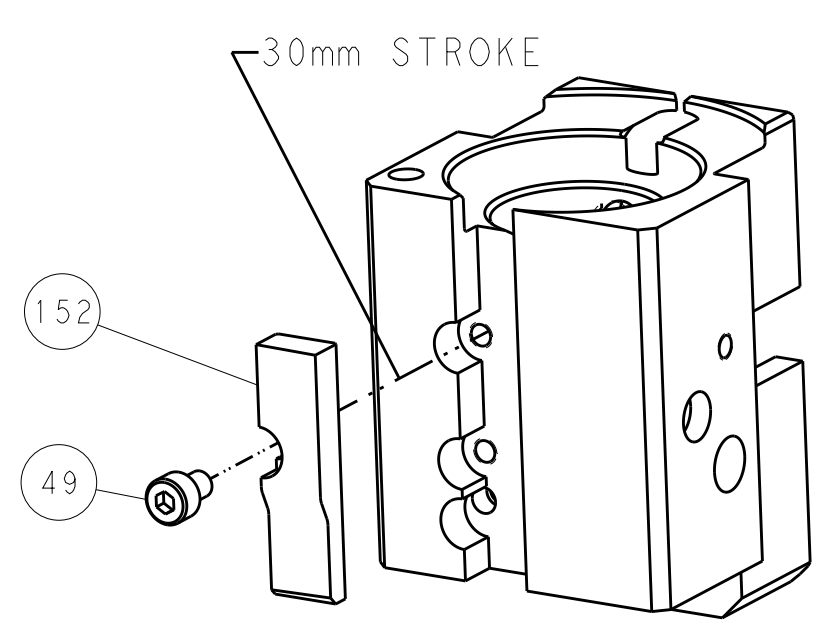
HOLDDOWN SET-UP

FEED TYPE

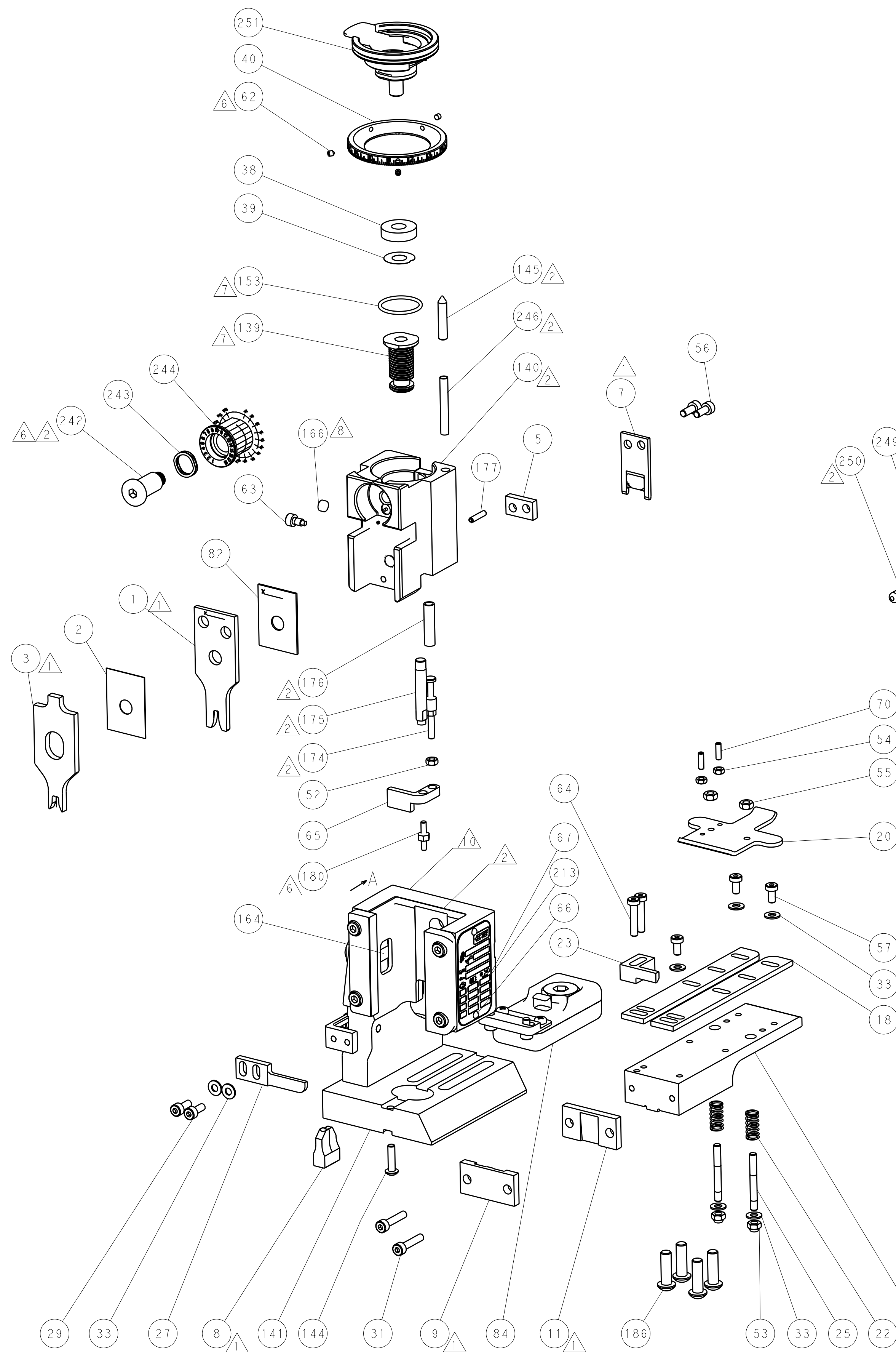
PNEUMATIC



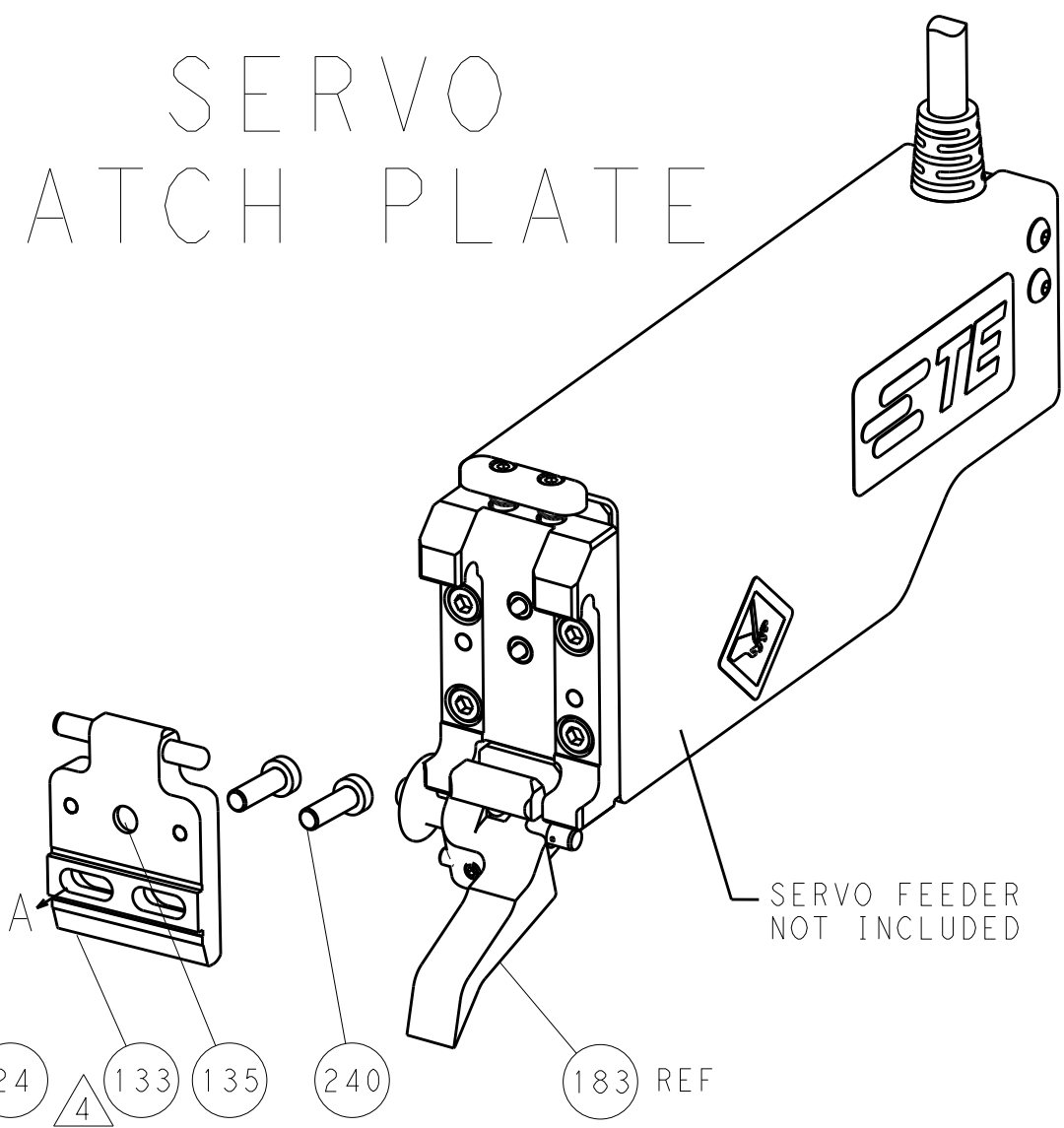
CAM POSITION



AIR FEED



SERVO LATCH PLATE



PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN Y. YIN 17AUG2015 CHK G. BAILEY 17AUG2015 APVD J. GUO 17AUG2015				STE TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH				NAME Ocean End Feed Applicator			
MATERIAL				PRODUCT SPEC				SIZE CAGE CODE DRAWING NO			
				APPLICATION SPEC				RESTRICTED TO			
				WEIGHT				A 00779 C=2150611			
				Customer Accessible Production Drawing				SCALE 1:1 SHEET 4 OF 4 REV A			